

Work Order ID 137929

October 15, 2015 2:05:19 PM

137929

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Item ID: D130-701-043 USED

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Heli-Utility-Basket™ - Airframe Mount, Fits LH or RH

Start Date: 10/15/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/16/2015 Req'd Qty: 1.00

1

Customer: CEURO01

Reference: RMA RA112163

Approvals: Process Plan: 20151015 Date: 20151015

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

100

0.00

100

QC

Quality Control

Memo

0.00

INSPECT D130-701-043 B126370 CHG 006 ON RA112163

STOCK IN QUARANTINE UNTIL FURTHER NOTICE

PROCEDURES TO FOLLOW

D 15-10-30DAS
9
9-89

110

0.00

110

Packaging

Packaging

Pick Kit

Memo

0.00

N/A

PD 15-11-19

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : _____							

Work Order ID 137929

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Item ID: D130-701-043 USED Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Heli-Utility-Basket™ - Airframe Mount, Fits LH or RH
Start Date: 10/15/2015 Start Qty: 1.00 ** Cust Item ID:
Required Date: 10/16/2015 Req'd Qty: 1.00 ** Customer: CEURO01
Reference: RMA RA112163

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC21- Final Inspection - Work Order Release	0.00							
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120

QC

Memo

0.00

Quality Control

Staying in Quarantine
until Engineers
decide if it can be
repainted.

20151102

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 1

Work Order ID: 137929

137929

Parent Item: D130-701-043 USED

D130-701-043 USED

Parent Item Name: Heli-Utility-Basket™ - Airframe Mount, Fits LH or RH

Start Date: 10/15/2015

Required Date: 10/16/2015

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D130-701-043 USED		Manufactured	No				Each	0.0000		1			

D130-701-043 USED

Heli-Utility-Basket™ - Airframe Mount, Fits LH or RH

SA 2015/10/15
B126370 - D130-701-043 x1.

RA112163

Received: October 6, 2015
Inspected: October 14, 2015

CUSTOMER: Airbus Blackcomb
CUSTOMER CONTACT: Joe Kadwell/Matt Melsness
SHIPPED FROM: Fort Erie, Ontario Canada

Instructions for RA112163 D130-701-043 B126370 CHG 006

- D130-701-043 B126370 was return. Customer not happy with design
- Basket was flown and as a lot of damage due to installation and some fitting issue
- Scuff and re-powder coat the following parts as per QSI 005 and stock with new batch number.
 - D4037-1 B67630
 - D4037-3 B71121
 - D4038-041 B71122
 - D4038-042 B69848
 - D4038-043 B71124
 - D4038-044 B69844
- Scrap the following parts. See attach picture for details
 - D3180-041 B71119. Forward section of strut was damage due to part rubbing on basket lid
 - D4039-041 B59135. Bottom .261" hole was elongated to .270". Signs showed of step rubbing on bracket
 - D4039-043 B58469. Bottom .261" hole was elongated to .266". Signs showed of step rubbing on bracket
- Founding on D2512 B89438
 - Little signs of damage can be stock as used as is
- Founding on D3172-041 B86121
 - D2012-117 back clevis are bent
 - D3174-1 mounting lugs are bent and .261" holes on are elongated to .282"
- Quality control recommendation is to scrap basket base due to the amount of work and labor involve on repairing it.

Time Estimate: 10 hours

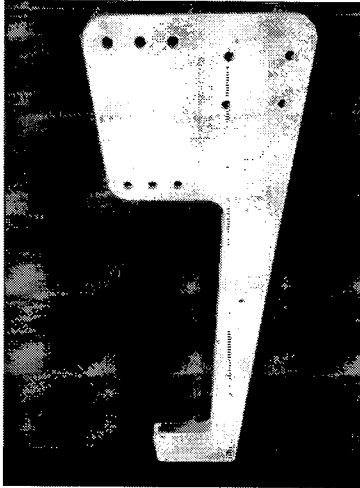
Departments Required: quality, small fab, finishing stores

Pictures Attached: yes

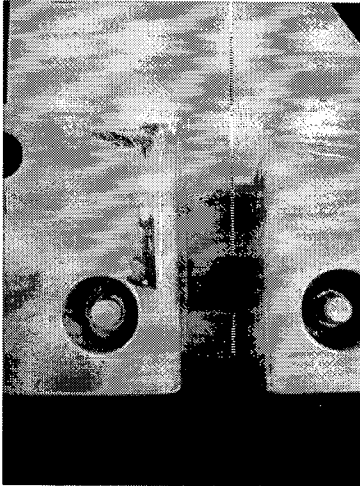
QTY INSPECTED: 1x D130-701-043 B126370 CHG 006

**THIS INSTRUCTION SHEET MUST BE
ATTACHED TO THE RESTOCKING
WORK ORDER AT ALL TIMES!!!!**

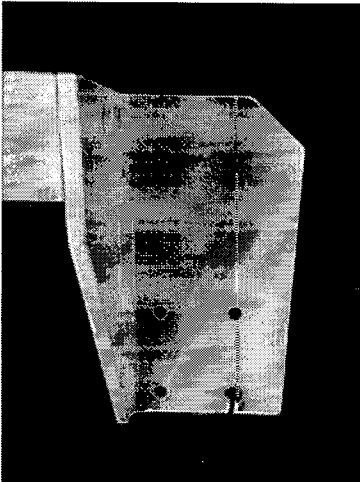
D4037-041



D4038



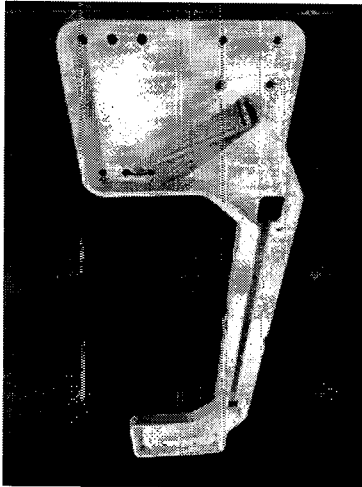
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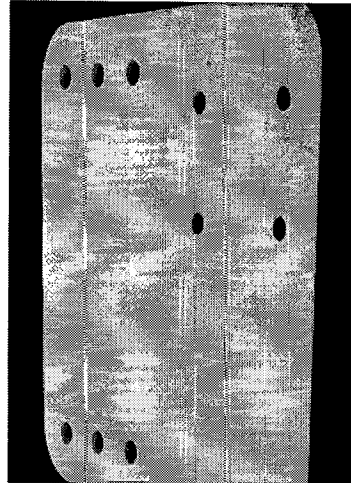
D4037-043



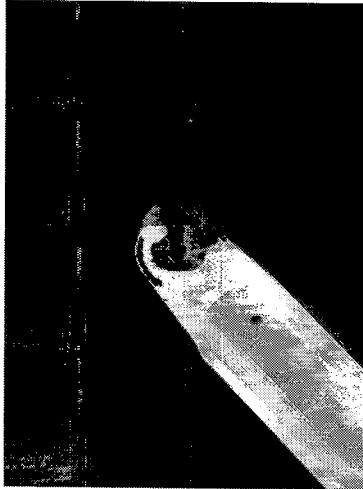
D4037-043



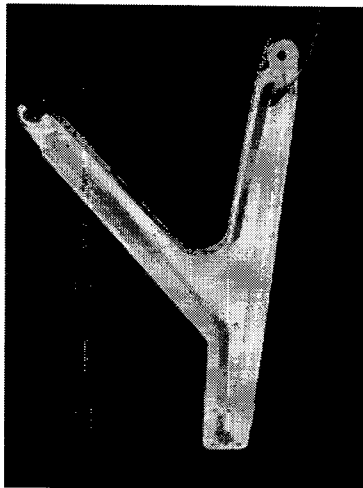
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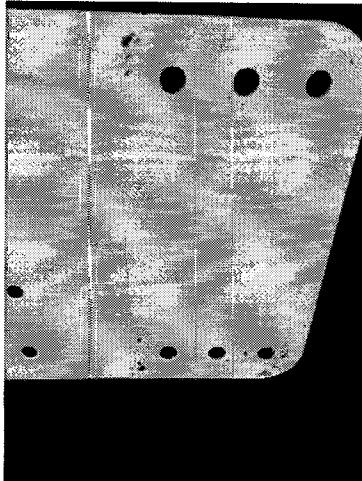
D4039-041



D4039-041



D4037-043



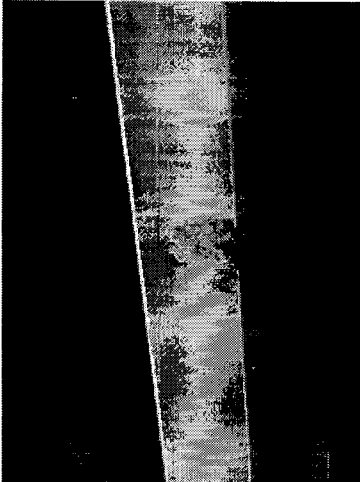
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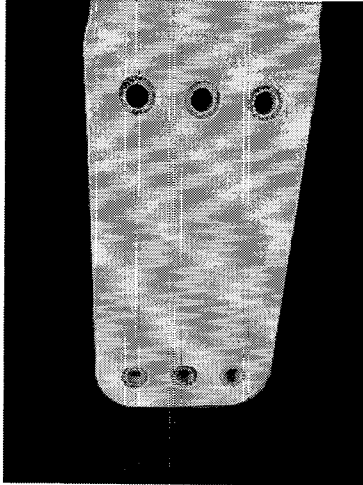
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D4039-041



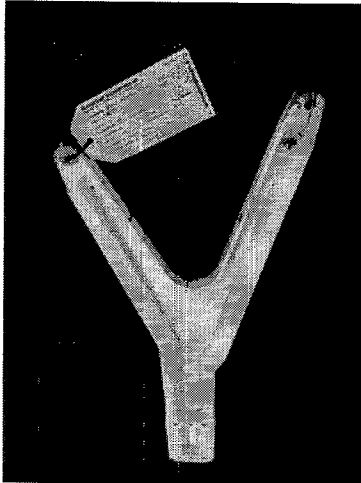
D4039-043



D4039-043



D4039-043



D4039-043



D4039-043



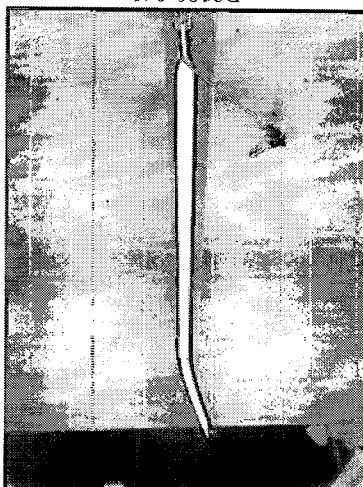
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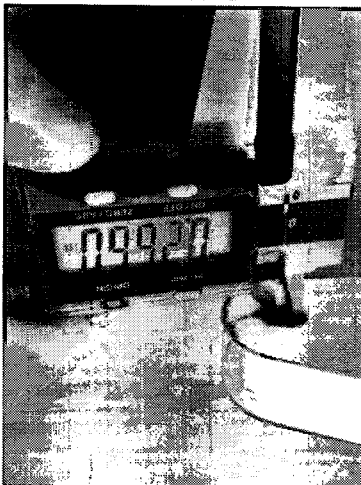
D3180-041



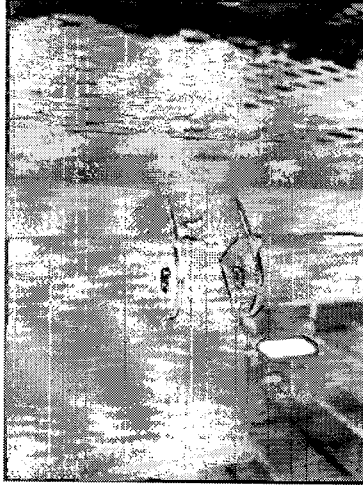
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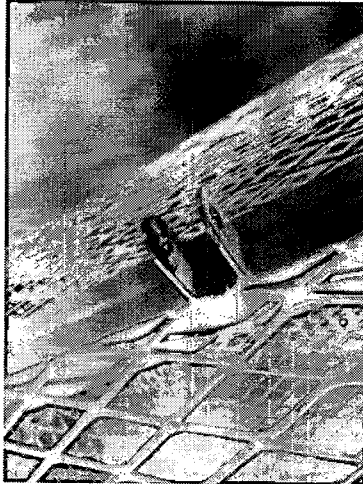
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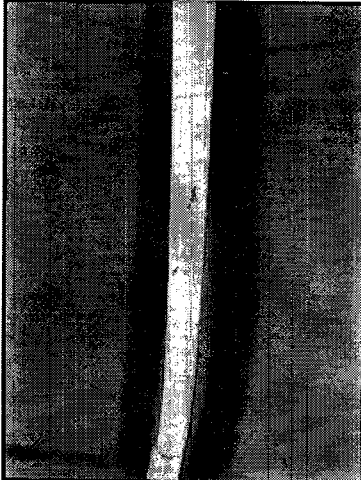
D2512 lid



D2512

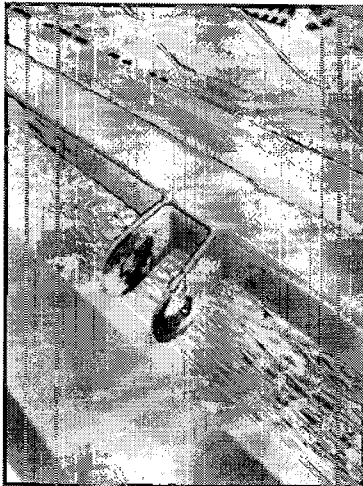


D3180-041





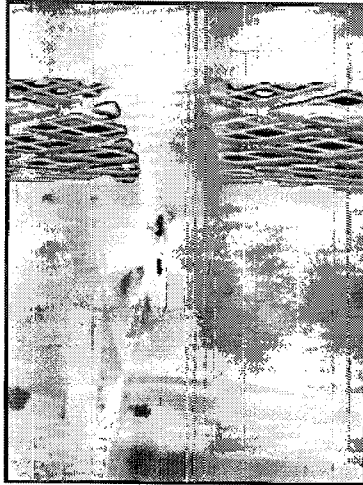
D3172-041 base



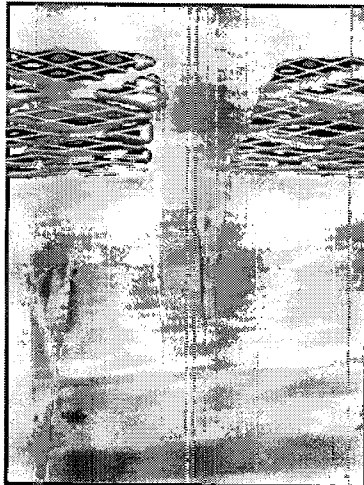
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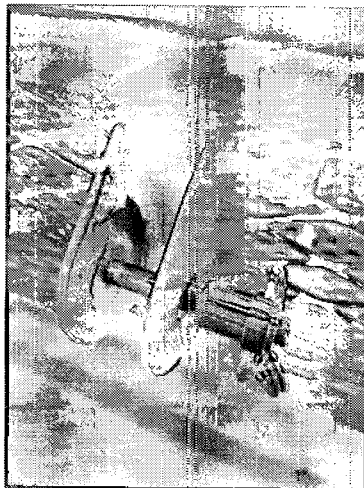
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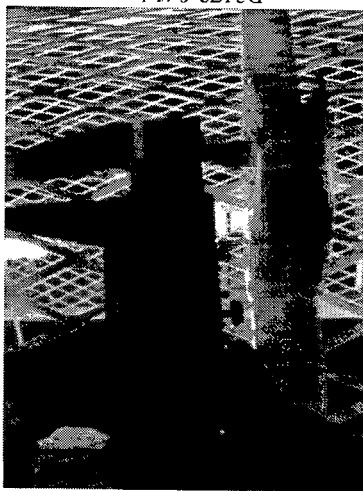
D3172-041 base



D3172-041 base



D3172-041 base



D3172-041 base